

### ABSTRACT OF THE DISCLOSURE

A method of forming a wound roll, such as a regenerator, including the steps of inserting wires at the lateral edges of an elongated strip as the strip is being wound around a spool. Spacers, such as localized bumps, are formed on the strip to space strip layers apart to form uniform gaps. An offset is added to the angle of rotation between  
5 each spacer-forming step to inhibit the nesting of bumps in the cavities of adjacent strip layers.